

5/23  
DART AEROSPACE LTD

Work Order:

23410

Description: Bushing

Part Number:

D2617-7

Dwg: D2617 Rev. E

Qty:

20

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PH	05.05.20	20
2	MC	Machine as per Folio FA454 and Dwg D2617 Material: Delrin Round Bar Ø0.500" (M-DELRIN-R0.500) Identify as D2617-7 Batch: M15637	S.G	05/05/20	20
3	QC2	Inspect parts as they come off the CNC machine	S.G	05/05/20	20
4	QC8	Second check	RC	05.05.20	20
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	S.G	05/05/20	20
6	QC5	Inspect work to Step 5	J	05.05.20	21
7	ST	Identify and Stock	CL	05/05/20	21
8	AC	Cost / part: 2.03	SUC	05-06-01	21
9	DC	Close W/O 2.03 Inspect Level 21	PH	05.06.06	21

Rev	Date	Change	Revised By	Approved
A	04.08.25	New Issue	KJ/JLM	

RELEASED  
2025-08-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

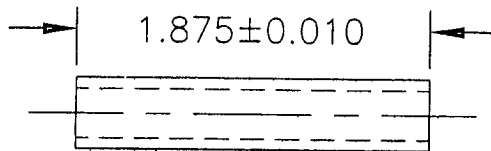


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE			TITLE		
01.07.04			BUSHING		
			SCALE		
			1:1		

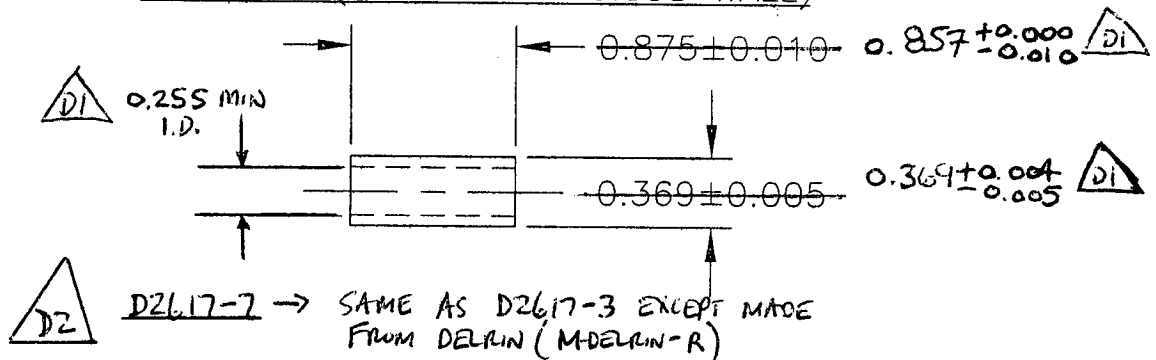
DZ 04.09.10 #CP ADD D2617-7

A	96.10.08	NEW ISSUE
B	97.05.08	.875 WAS 1.125
C	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
D1	CP 04.07.12	CORRECT TOLERANCE (NCR 779)

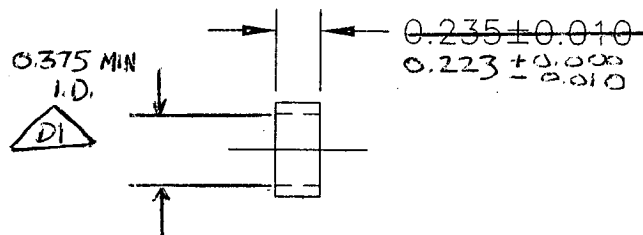
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #

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NOT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 23410

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 20, 2005  
01:40 pm

Work Order No : 0023410  
Project Name : D2617-7  
Project For : WK523  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2617-7  
Description : Bushing  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 05-20-05  
Est Finish Date : 06-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

